

Date: Monday, 1/7/2008 3:39:43 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BEARING	
Job Number	: 36648				
Estimate Number	: 10091				
P.O. Number	: N/A		Part Number	: D31835	
This Issue	: 1/7/2008	S.O. No. : N/A	Drawing Number	: D3183 REV. C1	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: C1	
Previous Run	: 36387		Material	: N/A	
Written By			Due Date	: 1/14/2008	
Checked & Approved By			Qty:	50 Um: Each	
Comment	: Est: A 09.03.27 New issue KJ/RF				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 5394

c 08/01/08 (50)

Bearing as per Dwg D3183

Single row, deep groove, Conrad type, shielded

Possible Supplier: NSK P/N 6800ZZ

Certificate of conformity note is required

2.0	6800ZZ	Bearing
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

BEARING

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure certificate of conformity is attached

1 - 8/01/10 (50)

4.0	Q06	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

6 - 08/01/11 (X50)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 75

AS 08/01/11 (X50)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes Yes No DQA: HD Date: 08/01/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 3:39:43 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING

Job Number: 36648

Part Number: D31835

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



50

Do810114

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08/01/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

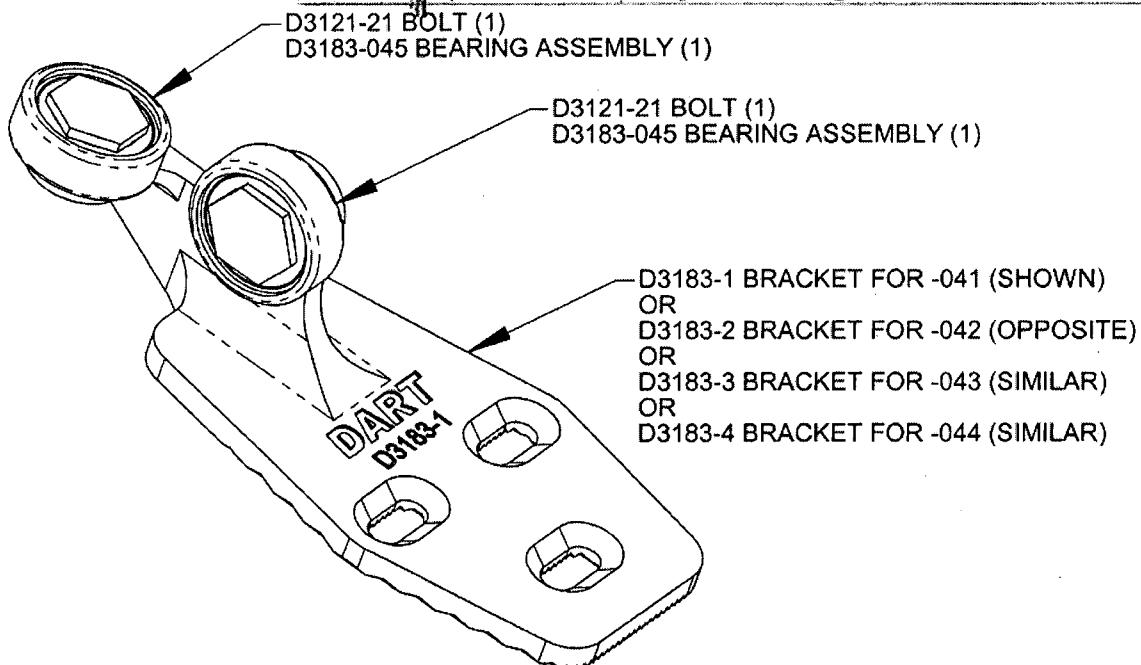
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

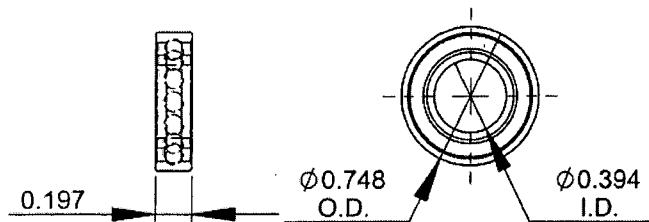
NOTE: Date & initial all entries

**DART**

DESIGN <i>#</i>	DRAWN BY <i>GP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1
A.	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045-9; 0.182 WAS 0.431	
C1	<del>04.11.09</del>	0.830 WAS 0.850	

**RELEASED**  
04.03.01 *[Signature]*

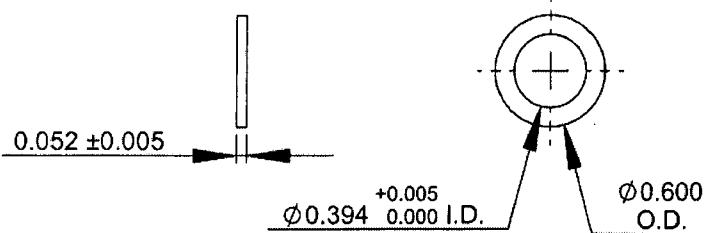
**D3183-041 BRACKET ASSEMBLY (SHOWN)**  
**D3183-042 BRACKET ASSEMBLY (OPPOSITE)**  
**D3183-043 BRACKET ASSEMBLY (SIMILAR)**  
**D3183-044 BRACKET ASSEMBLY (SIMILAR)**



#### **D3183-5 BEARING:** **SPECIFICATION CONTROL DRAWING**

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER NO. *36648*

#### **D3183-7 WASHER**

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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**DART**

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CENS

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b>
		HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3183
DATE	04.02.17	TITLE
		BRACKET ASSEMBLY
		SHEET 2 OF 4
		REV. C
		SCALE
		1:2

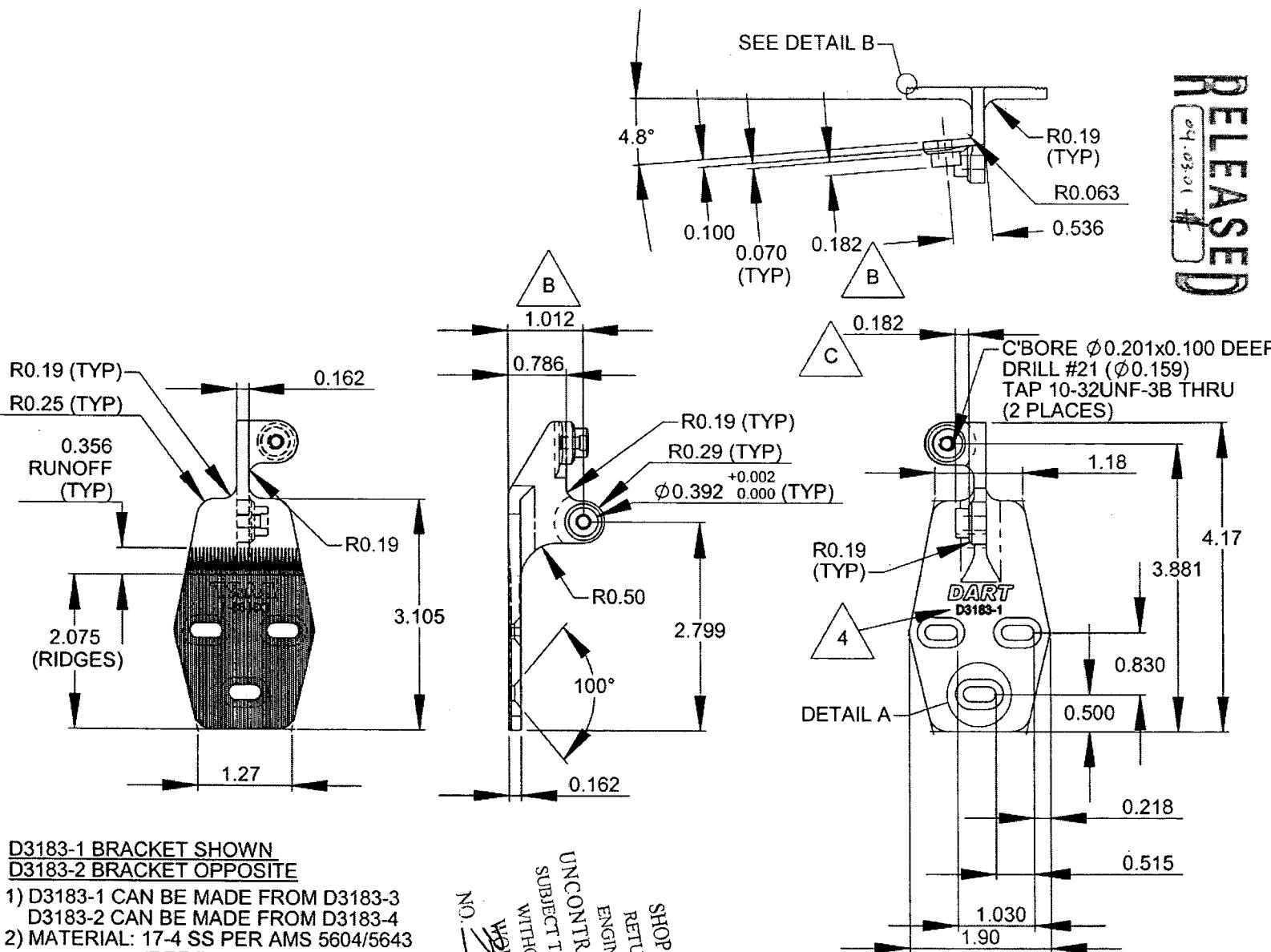
**RELEASED**

04.02.17

D3183-1 BRACKET SHOWN  
D3183-2 BRACKET OPPOSITE

- 1) D3183-1 CAN BE MADE FROM D3183-3  
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE STRENGTH = 150 ksi  
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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NO. WRC 008



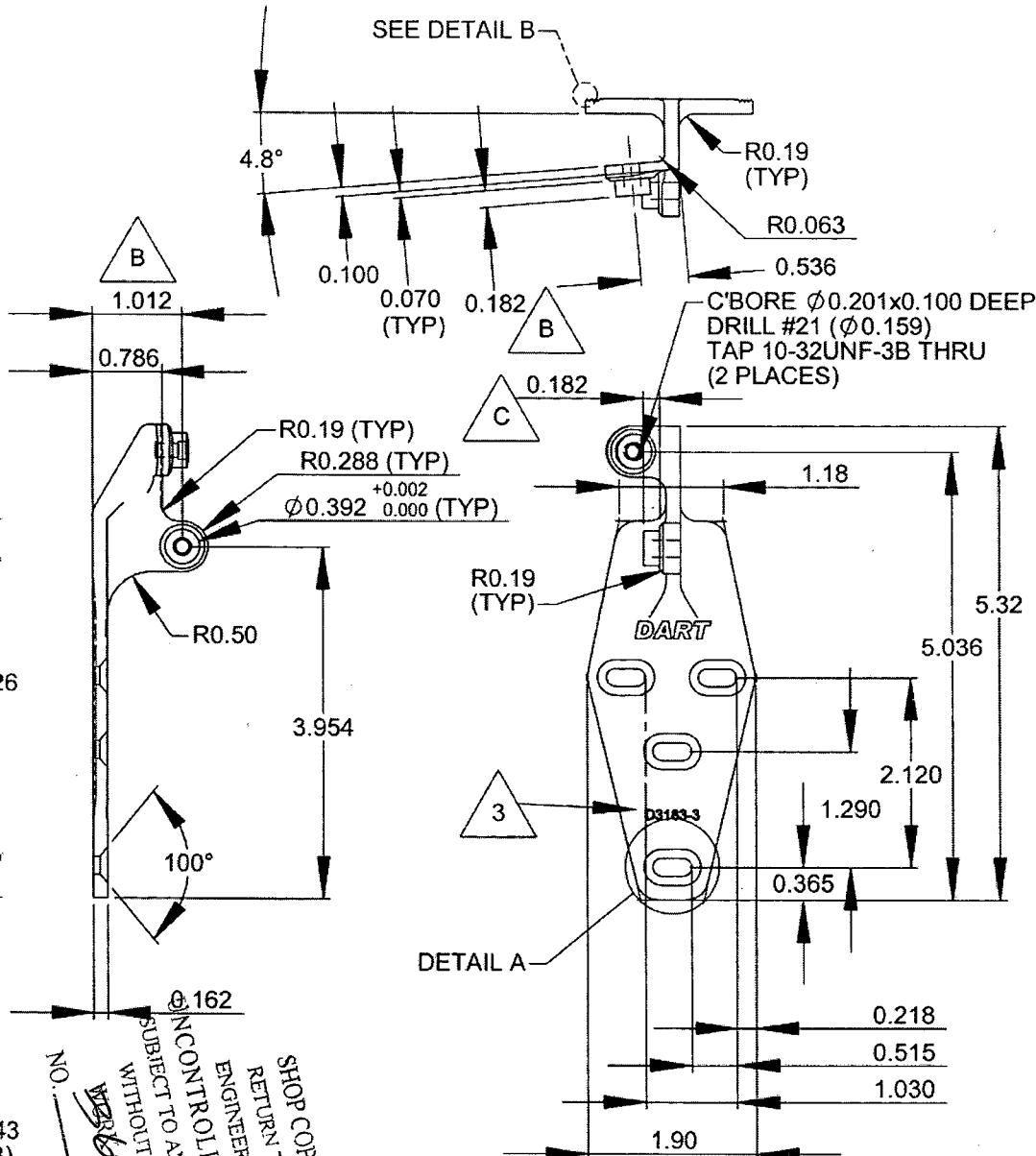
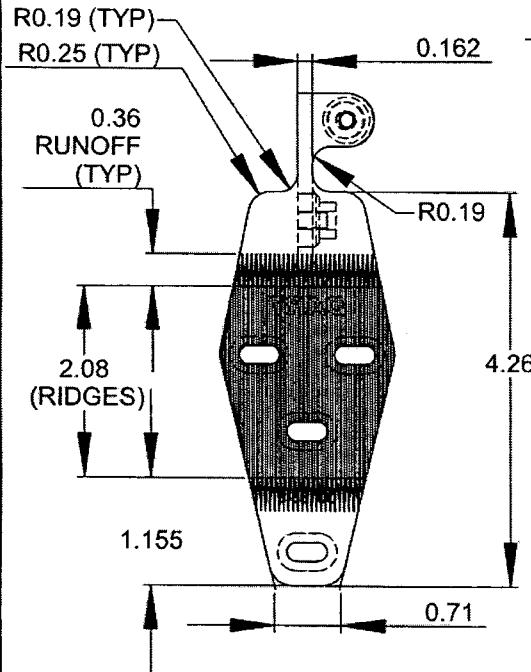
**DART**

COPY IS  
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		HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3183
DATE	04.02.17	TITLE
		BRACKET ASSEMBLY
		SHEET 3 OF 4
		REV. C
		SCALE
		1:2

**RELEASED**

JM 03.01



DETAIL A

D3183-3 BRACKET SHOWN  
 (REPLACES BELL P/N 412-030-304-105)  
D3183-4 BRACKET OPPOSITE  
 (REPLACES BELL P/N 412-030-304-106)

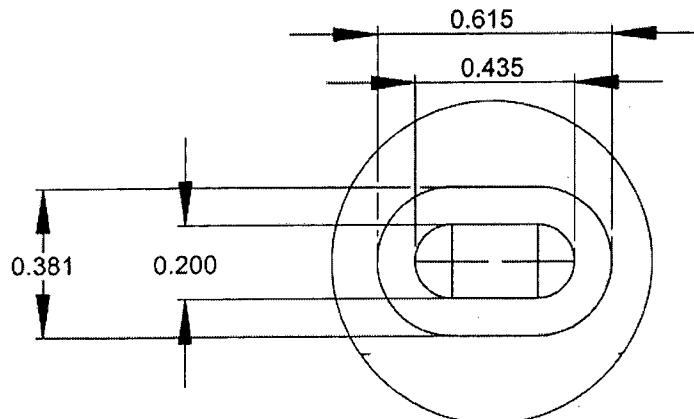
1) MATERIAL: 17-4 SS PER AMS 5604/5643  
 (REF DART SPEC. M17-4-B)  
 MIN ULTIMATE STRENGTH = 150 ksi  
 MIN YIELD STRENGTH = 100 ksi  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 NO. *W.B. 100-100*

2) BREAK ALL SHARP EDGES 0.005 TO 0.015  
 3) ENGRAVE DART P/N & LOGO AS SHOWN  
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
 5) ALL DIMENSIONS ARE IN INCHES

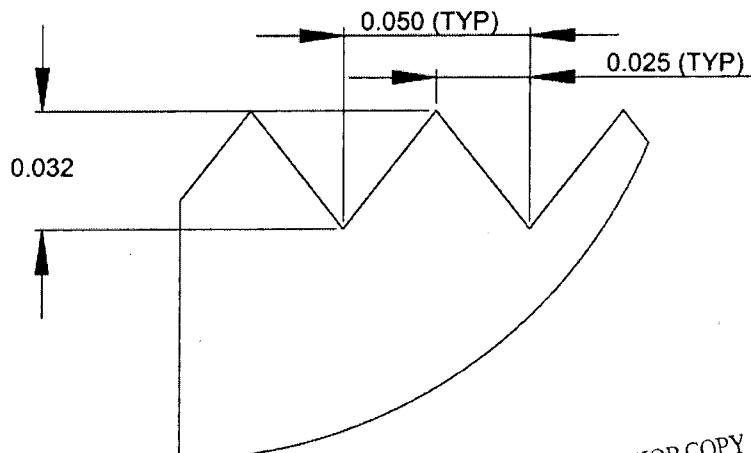
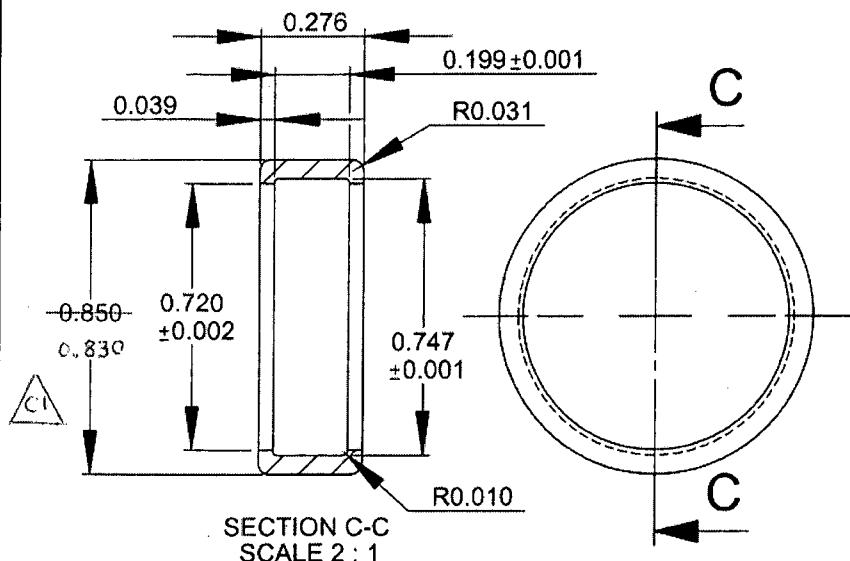
**DART**

DESIGN	DRAWN BY
CHECKED	APPROVED
DATE	04.02.17

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

REV. C  
SHEET 4 OF 4  
SCALE  
1:1
DETAIL A (2 : 1)**RELEASED**

04.03.01

DETAIL B (20 : 1)**D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00 (REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER  
NO. 36648

**D3183-045 BEARING ASSEMBLY**

- 1) ASSEMBLE D3183-5 BEARING AND D3183-9 CAP

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CIE GENERAL BEARING SERVICE • INC.

GST # R101979094

SOLD TO: DART AEROSPACE LTD.  
1270, ABERDEEN STREET  
HAWKESBURY, ON.

K6A-1K7

SALE MADE BY: SB  
SHIP VIA:

CUSTOMER ORDER #: 000065394

PST. LICENCE: 6122-5287

PRODUCT	DESCRIPTION	SOLD BY	SHIP BY	PRICE	EXTENSION
6800-ZZ	BALL BEARING	50	30	4.89	244.50
6900-ZZ	BALL BEARING	40	40	4.97	198.80

PACKING SLIP NO: 525624-0

RECEIVED BY:

Damon 14/70 384 409

THIS FORM MUST BE COMPUTER PRINTED TO BE VALID. IL EST DE  
DOIT ÊTRE IMPRIMÉ PAR ORDINATEUR POUR ÊTRE VALIDE. E. & T.E.

1284639